Work Order I January-24-14 8:25:			*111	878*						Page 1
Revision ID:	36-21 et Center		Accept	*N900	040°	1 ()	<b>)*</b> s	Setup Sta	171	S1* S2*
Start Date: 1/24 Required Date: 2/07 Reference:		1 /		Cust Item 1 Customer:	ID:					
	cess Plan: _ 从しづ		Tooling: SPC (Y/N):		ate:		R	Run Sta Sto	" <b>[V</b> ]	R1* R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID		Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr	- 1 10 10 10 10 10 10 10 10 10 10 10 10 1								
D3536	Rev A		0.00							
*100*  *100* Waterjet FLOW CNC Waterjet	FLOW WATER JET  Memo  1-Cut as p  Deburr if	per Dwg D3536 Dwg Rev:_ necessary	0.00 0.00 A Prog Rev: A	2-			_13_	<u>Ø</u>		JM14-02-20
110	QC2- Inspect parts off	machine FAI/FAIB	0.00				10			
*1 1 <b>A</b> * QC Quality Control	Memo		0.00				13_	<u> </u>		Jm14-02-20
120	QC8- Inspect parts - so	econd check	0.00 PAS 9.89				12	·		
*1 20* <sup>QC</sup>	Memo		1, 1, 1,	91			13			

Quality Control

DQA:	_		Date:			11/05// 05555 1/01/							TRAG
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE		ork Order up	ndate only	AEROSPACE
Q/ Closed.			Dutc.									• 1	1
Work Orde	er: .					DISPOSITION			AGAI	INST DE	PARTMENT,	PROCESS	
						Rework			Skid-tube Crossi			Water Jet	Engineering
Part N	Ю.					Scrap			Machining Small		1	d. Eng. Coor.	Quality
NCR No.				Use-as-is Suspected Unapproved			noforming Finis Large Fab Compo	hing osite	Rec/Stor	e/Packaging Supplier	Other		
	•						ı						اسا
Root					Desc	ription of work order update		nitial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design													
Doc/Data													'
Equip/Tooling Handling/Pre													
Material													
Operator													
Offset/Setup													
Process													
Supplier													
Training													
Transport							l						
Unapproved													
							FA	ULT CA	TEGORY				
Landi	_	1			_	General		1			1	_	¬
		Bending	_		<u> </u>	Bend	<u> </u>	1	Program	<u> </u>	Outside Dim	<del>-</del>	Pressure/Forced
		Centre No	ot Concer	ntric	<u> </u>	BOM/Route	_	Grain		<u> </u>	Over/Under	⊢	Set-up
	_	Cracks				Broken/Damage/Defect	$\vdash$	Hardwa			Part Incorred	<u> </u>	Temperature/Cure
	-	Crimp/Kink/Ripple/Wave			-	Burrs	$\vdash$	1 '	ion Incomplete/Unqualified	' <u> </u>	Part Lost/Mi	ssing	Weld
		Cuffs			-	Countarink	-	4	tions Incomplete/Unclear	-	Part Moved	L.	Wrong Stock Pulled
	Crushing Heat Treat				-	Countersink Cut Too Short	-	Mislab	gned/off center	<u> </u>	Positioned V Power Loss/		Other
	Inspection Strip in Tube			Tube	-	Drawing	H	Misrea		L	1. ower coss/.	L L	Totalei
	Marks/Chatter					Drill Holes	$\vdash$	Off-set					
	Turning Sequence					Finish		4	Calibration				
		Wave/Twist in Tube				Fit/Function		-	Sequence				

<b>Work Order</b>	ID	111878
-------------------	----	--------

\*111878\*

Page 2

January-24-14 8:25:29 AM Item ID: D3536-21 Accept \*N900040100\* Setup Start **Revision ID:** Stop Item Name: Gasket Center **Start Qty: 12.00** \*12\* **Start Date:** 1/24/14 **Cust Item ID:** Required Date: 2/07/14 Rea'd Otv: 12.00 \*19\* **Customer:** Reference: Run Approvals: Date: Tooling: Date: Stop Date: OC: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool # Plan Reject Tool ID Accept Reject Insp. Work Center ID **Description** Run Hours Otv Number Code Oty Stamp Identify as per dwg & Stock Location: F(2-66) 130 \*120\* Packaging 0.00 Memo Packaging 140 QC21- Final Inspection - Work Order Release 0.00 \*140\* QC 0.00 Memo **Quality Control** 

DQA:			Date:												
						WORK ORDER NON-	-CC	ONFO	RMANCE / UF						AEROSPACE
QA Closed:			Date:								Wo	ork Order up	date only		
Work Orde	r:					DISPOSITION				AGAINST	T DEPARTMENT/PROCESS				
	·· -					Rework	1		Skid-tube	Crosstube		Water Jet			Engineering
Part N	0.					Scrap			Machining	Small Fab		<b>→</b>			Quality
	-					Use-as-is		Therr	moforming	Finishing		Rec/Stor	e/Packaging		Other
NCR N	NCR No.				Suspected Unapproved	]		Large Fab	Composite			Supplier	_]		
Root	1				Desci	ription of work order update	Ī	nitial	Acti	on		Sign &			
Cause	ightharpoonup	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption		Date	Verification	$\sqcup$	QC Inspector
Design	_											:			
Doc/Data	_						l								
Equip/Tooling	$\dashv$														
Handling/Pre															
Material	_	:													
Operator Offset/Setup	$\dashv$														
Process	ᅱ														
Supplier	ᅦ														
Training															
Transport														ļ	,
Unapproved														İ	
							FA	ULT CA	TEGORY						
Landin	ng G	iear.				General							_		
		Bending				Bend		1	Program			Outside Dim	<del> </del>	$\overline{}$	Pressure/Forced
		Centre No	t Concer	ntric		BOM/Route	_	Grain				Over/Under	<del>-</del>		Set-up
	$\dashv$	Cracks			<u> </u>	Broken/Damage/Defect	<u> </u>	Hardwa				Part Incorre			Temperature/Cure
	_	Crimp/Kin	ık/Ripple	/Wave		Burrs	<u></u>	1	tion Incomplete/Un	•		Part Lost/Mi	· -	_	Weld
		Cuffs				Contamination	$\vdash$	4	tions Incomplete/U	Inclear		Part Moved			Wrong Stock Pulled
<b> </b>	Crushing				$\vdash$	Countersink	$\vdash$	•	gned/off center			Positioned V	_	—	lou
	Heat Treat			Tuk-	-	Cut Too Short	-	Mislab				Power Loss/	Surge		Other
	Inspection Strip in Tube				$\vdash$	Drawing Drill Holes	$\vdash$	Misrea Off-set				-			
	Marks/Chatter Turning Sequence				$\vdash$	Finish	-	4	Calibration			-		_	
}					$\vdash$		-	-1				-			
L		Wave/Twist in Tube				Fit/Function	1	Out of	Sequence						

Page 1

January-24-14 8:25:33 AM

Work Order ID: 111878

\*111878\*

Parent Item:

D3536-21

\*D3536-21\*

Parent Item Name: Gasket Center

**Start Date: 1/24/14** 

Required Date: 2/07/14

**Start Otv: 12.00** 

Required Qty: 12.00

**Comments:** 

IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf	44.1000	0.8503	(12)			· ····
*MNFO60									**			Ju	14-02

## MMH0608 063\*

NEOPRENE SHEET 0.063

Loc Qty Loc Code Location MAT052 44.1 M126546 44.1

128266

128266

DQA:			Date:											
_						<b>WORK ORDER NON-</b>	-CC	ONFO	RMANCE / UP[	DATE			AEROSPACE	
QA Closed:			Date:							W	ork Order up	date only		
Work Orde	·r·					DISPOSITION				AGAINST D	EPARTMENT,	PROCESS		
Work Orac	٠	,				Rework	1 I		Skid-tube	Crosstube	1	Water Jet Engine		
Part N	lo.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality	
1 4.01						Use-as-is					Other			
NCR No.				Suspected Unapproved			~ <b>—</b>	Composite	1 '	Supplier	1			
	•						•					· · · · · · · · · · · · · · · · · · ·		
Root					Desci	ription of work order update	I	nitial	Actio	n	Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descrip	tion	Date	Verification	QC Inspector	
Design														
Doc/Data							l							
Equip/Tooling														
Handling/Pre			-											
Material												- - -		
Operator				•							!			
Offset/Setup													•	
Process		'												
Supplier												·		
Training														
Transport														
Unapproved		<u> </u>			<u> </u>			=						
							FA	ULI CA	TEGORY					
Landii	_	ı				<b>General</b> Bend <sup>*</sup>		]/	Drogram	Г	Outside Dim	onsions [	Pressure/Forced	
,		Bending Centre No	-+ Camaan	.+=:.	-	BOM/Route	$\vdash$	Grain	Program	⊢	Over/Under	<u> </u>	Set-up	
	_	Cracks	or concer	ittic		Broken/Damage/Defect	$\vdash$	Hardwa	aro	<del> -</del>	Part Incorred	<u> </u>	Temperature/Cure	
			sk/Binnlo	Mayo	-	Burrs	$\vdash$	4	are tion Incomplete/Unq	ualified	Part Lost/Mi	<b></b>	Weld	
		Crimp/Kir	ik) vihbie	y wave	-	Contamination	$\vdash$	4 '	ctions Incomplete/Un	<u> </u>	Part Moved	338118	Wrong Stock Pulled	
	Crushing				-	Countersink	-	-	gned/off center	-	Positioned V	L_ Vrong	THE STOCK Fulled	
	$\vdash$	Crushing Heat Trea	1		Cut Too Short Mislabe			-	-	Power Loss/		Other		
	Inspection Strip in Tube Drawing			<b>-</b>		Misrea		<b>L</b>	٠٠٠٠ الم		1-3			
	Marks/Chatter			Drill Holes	$\vdash$	Off-set								
				Finish	$\vdash$	-	Calibration		<del></del>					
	Wave/Twist in Tube			F	Fit/Function		Out of Sequence							

DART AEROSPACE LTD	Work Order:	111848		
Description: Gasket	Part Number:	D3536-21		
Inspection Dwg: D3536 Rev: A	·	Page 1 of 1		

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
32.70	+/-0.030	32.70°	_		T	JAMOG
27.25	+/-0.030	27.25	_		T	
21.80	+/-0.030	21.80	-		т	
16.35	+/-0.030	16.35	_		Ť	
10.90	+/-0.030	10.90	-		T	
5.45	+/-0.030	5,45			V	
24.00	+/-0.030	24.00"	_		T	
16.00	+/-0.030	16.000			T	
8.00	+/-0.030	8,000	-		V	Thmol
6.00	+/-0.030	6.00	-		V	
2.00	+/-0.030	2.00"	-		ν	
0.90	+/-0.030	0.90	_		V	
0.30	+/-0.030	6.30"	_	·	V	
0.30	+/-0.030	0.30"			V	
1.89	+/-0.030	1.89	_		V	
Ø0.19	+0.004/-0.001	0.19"	_		ν	
					w	
				. ,		

Measured by: Jm Audited by: 9-89 Prototype Approval: N/A

Date: 14.03.20 Date: 14.22 Date: N/A

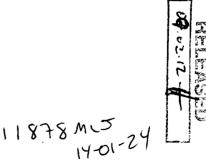
Rev	Date	Change	Revised by	Approved
Α	08.02.28	New Issue	KJ/DD X	7
			()	

DQA:			Date:												
						<b>WORK ORDER NON-</b>	-CC	ONFO	RMANCE / UPD	ATE			AEROSPACE		
QA Closed:			Date:							W	ork Order up	date only			
W-1 0-1						DISPOSITION				AGAINST DE	PARTMENT	PROCESS			
Work Orde	er: .					,	,		a — _		1	\\\.	, <del>, , , , , , , , , , , , , , , , ,</del>		
D = A	1					Rework		Skid-tube Crosstube			-	Water Jet	Engineering		
Part N	10.				—	Scrap Use-as-is			<b>Ŭ</b>	Small Fab Finishing	4	d. Eng. Coor.	Quality		
NCR N	ما					Suspected Unapproved		mem	· -	omposite	Kec/Stor	e/Packaging Supplier	Other		
NCK	١٠.					Suspected Onapproved	]		Laige Fab C	Oli iposite[	J	3upplier	. L		
Root					Desci	ription of work order update		nitial	Action		Sign &				
Cause		Date	Step	Qty		or non-conformance	1	ief Eng			Date	Verification	QC Inspector		
Design			•												
Doc/Data															
Equip/Tooling															
Handling/Pre									Į						
Material															
Operator															
Offset/Setup															
Process			]												
Supplier							1								
Training															
Transport									-						
Unapproved															
							FA	ULT CA	TEGORY						
Landi		l				General		1 ,_	_		7	. –	7		
	_	Bending	_		$\vdash$	Bend	_	4	Program	<u> </u>	Outside Dim	<u> </u>	Pressure/Forced		
		Centre No	ot Concen	itric	-	BOM/Route	_	Grain		-	Over/Under		Set-up		
		Cracks	- I. /D'!	644	_	Broken/Damage/Defect	$\vdash$	Hardwa			Part Incorred	<del> </del>	Temperature/Cure		
	<u> </u>	Crimp/Kir	nk/kipple,	/wave	<u> </u>	Burrs	$\vdash$	<b>-</b> 1 '	ion Incomplete/Unqua	<u> </u>	Part Lost/Mi	ssing	Weld		
		Cuffs			-	Countarink	_	4	tions Incomplete/Uncl	ear	Part Moved	L.	Wrong Stock Pulled		
	Crushing				$\vdash$	Countersink Cut Too Short	$\vdash$	Mislabe	gned/off center		Positioned V Power Loss/		Other		
	Heat Treat Inspection Strip in Tube		$\vdash$	Drawing	$\vdash$	Misrea			7. OMEL F033/		Totaler				
	Marks/Chatter			Drill Holes	$\vdash$	Off-set			-						
	Turning Sequence			Finish		4	Calibration								
	Wave/Twist in Tube			e		Fit/Function		Out of Calibration Out of Sequence							

돺 DOCUMENT ᄶ Copyright @ 2006 by DART AEROSPACE USA, INC.

PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. PURPOSE 유 COPIED

26.65 23.15 21.15 17.65 13.40 -0.90 - 5.65 1.89 3.90 DETAIL A #0.19 (TYP 3 PLS) D3536-11 GASKET





06.10.25

GASKET

06.10.25

NEW ISSUE

DATE

£

D3536

SHEET

1 OF 6 SCALE

DRAWING NO

DART

AEROSPACE PORT HADLOCK

**USA** 

NO.

B

١	1	8+8	MC 24
		•	14-01-24
			• •

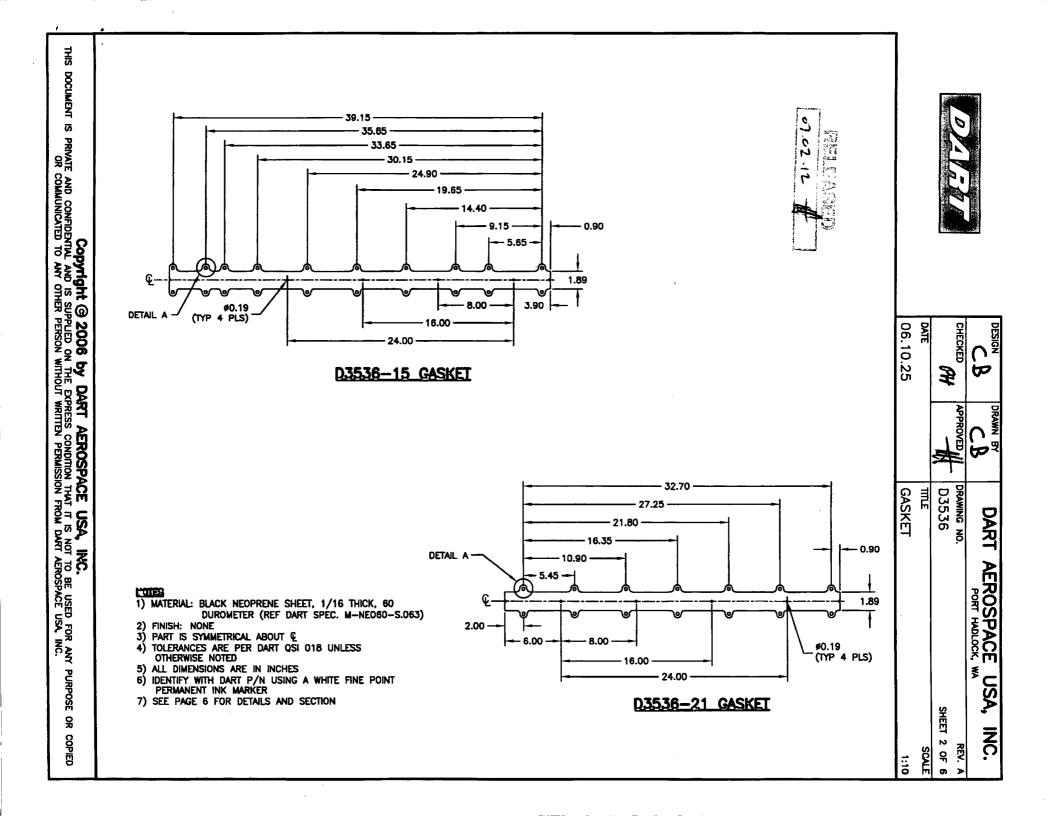
32.90	
29.40	
27.40	
23.90	
18.98	
14.07 9.15 	<u> </u>
DETAIL A 8.00 3.90  (TYP 4 PLS) 20.00	1 1

D3536-13 GASKET

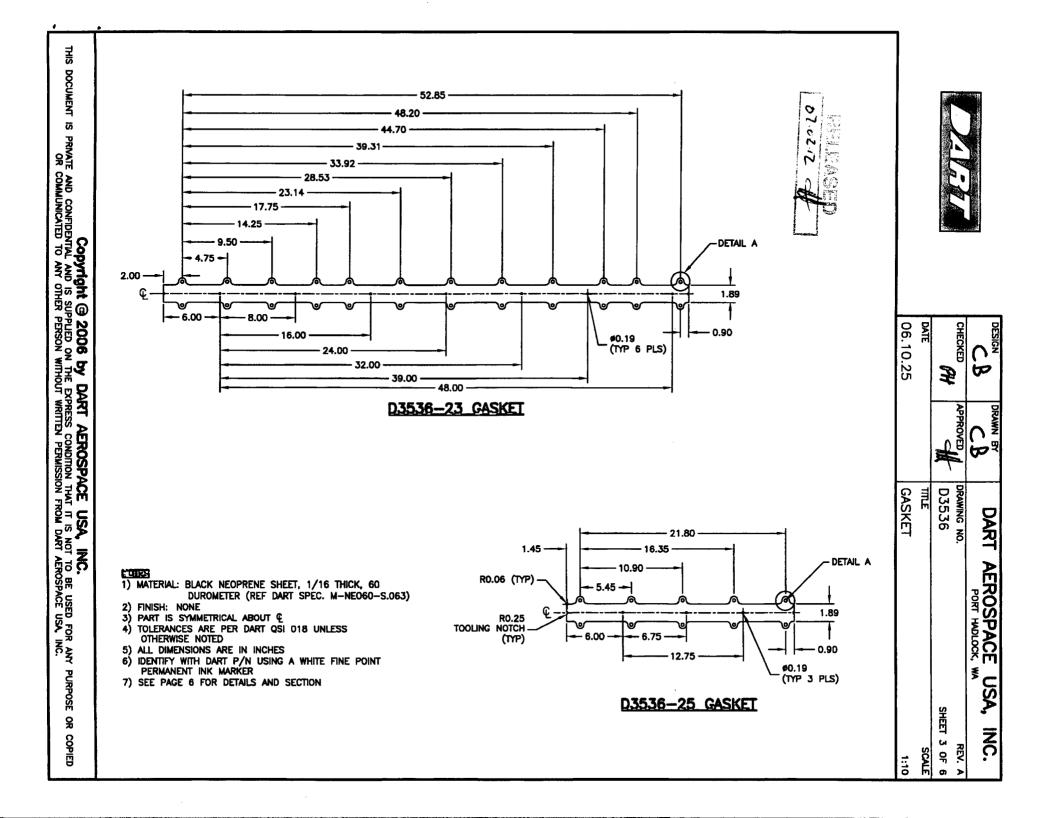
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

- 2) FINISH: NONE
  3) PART IS SYMMETRICAL ABOUT ©
  4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
  6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

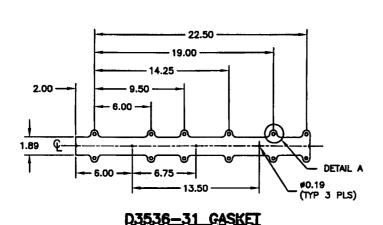
DQA:			Date:					NDT								
						WORK ORDER NON	WORK ORDER NON-CONFORMANCE / UPDATE									
QA Closed:			Date:			Work Order update only										
Work Orde	er:					DISPOSITION				AGAINST [	DEPA	PEPARTMENT/PROCESS				
	-					Rework	Skid-tube Crosstube					Water Jet	Engineer	ring		
Part N	lo.					Scrap			Machining Small Fab			Pro	d. Eng. Coor.	Qua	-	
	•					Use-as-is		Thern	moforming Finishing		Rec/Store/Packaging			Ot	her .	
NCR N	۱o.				ˈ	Suspected Unapproved			Large Fab	Composite			Supplier			
													·			
Root					Desci	ription of work order update		nitial	ì	tion	1	Sign &	_			
Cause	$\dashv$	Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription	_	Date	Verification	QC Ins	pector	
Design	Щ						l									
Doc/Data																
Equip/Tooling												:		j		
Handling/Pre			i	:												
Material	$\Box$								5 1							
Operator	$\dashv$	_														
Offset/Setup																
Process	$\dashv$										ŀ					
Supplier Training							Ì									
Transport																
Unapproved							ļ						•			
			1	1			FA	ULT CA	TEGORY							
Landi	ng G	ear				General		<u> </u>		10. 10.						
	$\overline{}$	Bending				Bend		Folio/F	Program			utside Dim	ensions	Pressure/Fo	orced	
		Centre No	ot Concer	ntric		BOM/Route	Г	Grain	Togram			ver/Under	tolerance	Set-up		
	Cracks					Broken/Damage/Defect	Г	Hardwa	are	Γ	Pa	art Incorred	: [	Temperatu	re/Cure	
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/U	Inqualified	Pa	art Lost/Mi	ssing	Weld		
		Cuffs				Contamination		Instruc	tions Incomplete/	'Unclear	Pa	art Moved		Wrong Stoo	ck Pulled	
		Crushing				Countersink		Misali	gned/off center	·	Po	ositioned V		<u>_</u>		
		Heat Trea	ıt			Cut Too Short		Mislabe	eled		Po	ower Loss/	Surge	Other		
		Inspection	n Strip in	Tube		Drawing		Misrea	d	_	_					
		Marks/Ch	atter			Drill Holes		Off-set								
		Turning S	equence			Finish		Out of	Calibration							
		Wave/Tw	ist in Tub	oe		Fit/Function Out of Sequence										

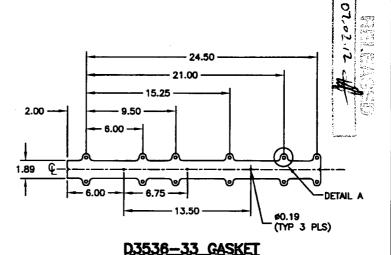


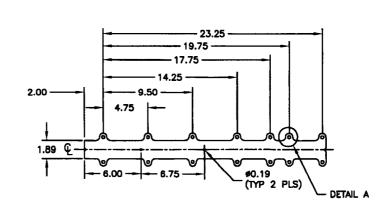
DQA:			Date:			- Wark apper han conformance (Uppare										
04 (1		WORK ORDER NON-CONFORMANCE / UPDATE  Date: Work Order update only														
QA Closed:			Date:													
Work Orde	r.					DISPOSITION	•		AGAINS	T DE	EPARTMENT/PROCESS					
· · · · · · · · · · · · · · · · · · ·	••••				_	Rework			Skid-tube Crosstub	eГ	Water Jet Engineering			Engineering		
Part N	Part No.					Scrap			Machining Small Fa	_	Prod. Eng. Coor.			Quality		
	t are no.					Use-as-is			noforming Finishin	_	Rec/Store/Packaging			Other		
NCR N	۱о.					Suspected Unapproved Large Fab Composi				e	]	Supplier				
Root					Desci	ription of work order update		nitial	Action		Sign &		一	*		
Cause		Date	Step	Qty	Desci	or non-conformance	i	ief Eng			Date	Verification		QC Inspector		
Design		Dute	Jiep	Q.,		or non comormance	<u> </u>		Description		Dute	7 011110411011	$\dashv$	Quinoposto.		
Doc/Data																
Equip/Tooling																
Handling/Pre												i	-			
Material													ł			
Operator													-			
Offset/Setup													١			
Process									:				-			
Supplier													١			
Training																
Transport													ľ			
Unapproved						· · · · · · · · · · · · · · · · · · ·							$\perp$			
							FAI	ULT CA	TEGORY							
Landi	ng (	Sear			_	General		1			7	_				
		Bending			_	Bend	<u> </u>	•	Program	L	Outside Dim	-		Pressure/Forced		
	ldash	Centre No	ot Concer	ntric		BOM/Route		Grain		<u>_</u>	Over/Under			Set-up		
		Cracks			<u> </u>	Broken/Damage/Defect	<u> </u>	Hardwa			Part Incorre	<del>-</del>	$\neg$	Temperature/Cure		
		Crimp/Kir	nk/Ripple	/Wave	ļ	Burrs	L	1 '	ion Incomplete/Unqualified	$\perp$	Part Lost/Mi	issing	$\dashv$	Weld		
		Cuffs			<u> </u>	Contamination		4	tions Incomplete/Unclear	$\perp$	Part Moved	L	_}	Wrong Stock Pulled		
	<u> </u>	Crushing			<u> </u>	Countersink		4	gned/off center		Positioned V	Ť	<del></del>	1		
	<u> </u>	Heat Trea			<u> </u>	Cut Too Short		Mislab		L	Power Loss/	Surge [	[	Other		
	<u> </u>	Inspectio	-	Tube	$\vdash$	Drawing	_	Misrea								
	<u> </u>	Marks/Ch				Drill Holes	<u> </u>	Off-set			-					
	_	Turning S			<u> </u>	Finish	<u>_</u>	4	Calibration					<del>.</del> .		
l	ļ.	Wave/Tw	ist in Tub	oe -		Fit/Function		Out of	Sequence			<u></u>				



DQA:			Date:														
						WORK ORDER NON-	WORK ORDER NON-CONFORMANCE / UPDATE										
QA Closed:			Date:	: Work Order update only													
Work Orde	er:					DISPOSITION			AGAINST								
					_	Rework			Skid-tube Crosstube		]	Water Jet	Engineering				
Part f	Part No.				Scrap			Machining Small Fab	-	Pro	d. Eng. Coor.	Quality					
				Use-as-is			moforming Finishing		4	re/Packaging	Other						
NCR I	۱o.					Suspected Unapproved Large Fab C					]	Supplier					
Root					Desc	ription of work order update		nitial	Action		Sign &						
Cause		Date	Step	Qty		or non-conformance	ı	ief Eng	ł.		Date	Verification	QC Inspector				
Design			,	- 7					• • • • • • • • • • • • • • • • • • • •				<u> </u>				
Doc/Data																	
Equip/Tooling			-				1										
Handling/Pre																	
Material																	
Operator							l										
Offset/Setup												:					
Process																	
Supplier																	
Training																	
Transport																	
Unapproved																	
							FA	ULT CA	TEGORY								
Landi	ng (	1				General		3		_	7		<del>_</del>				
		Bending				Bend	Folio/Program			<u> </u>	Outside Dim	<b>—</b>	Pressure/Forced				
	<u> </u>	Centre No	ot Concer	ntric	_	BOM/Route		Grain			Over/Under	<b>—</b>	Set-up				
	Cracks				_	Broken/Damage/Defect		Hardwa		<u> </u>	Part Incorre	<u> </u>	Temperature/Cure				
		Crimp/Kink/Ripple/Wave				Burrs	_	i	ion Incomplete/Unqualified	$\vdash$	Part Lost/Mi	ssing	Weld				
	<del></del>	Cuffs				Contamination		4	tions Incomplete/Unclear	L	Part Moved	L	Wrong Stock Pulled				
	<u> </u>	Crushing			-	Countersink		1 '	gned/off center	$\vdash$	Positioned V		¬				
	_	Heat Trea				Cut Too Short	$\vdash$	Mislab		L	Power Loss/	Surge	Other				
	<u> </u>	Inspection		Tube	_	Drawing	-	Misrea									
	_	Marks/Ch				Drill Holes	_	Off-set									
	<u> </u>	Turning S			_	Finish	$\vdash$	4	Calibration								
ŀ	1	Wave/Tw	ist in Tub	oe		Fit/Function		Out of	Inction Out of Sequence								







D3536-35 GASKET

10	
	MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60
•	DUROMETER (REF DART SPEC. M-NEO60-S.063)
2)	FINISH: NONE
	PART IS SYMMETRICAL ARCHIT &

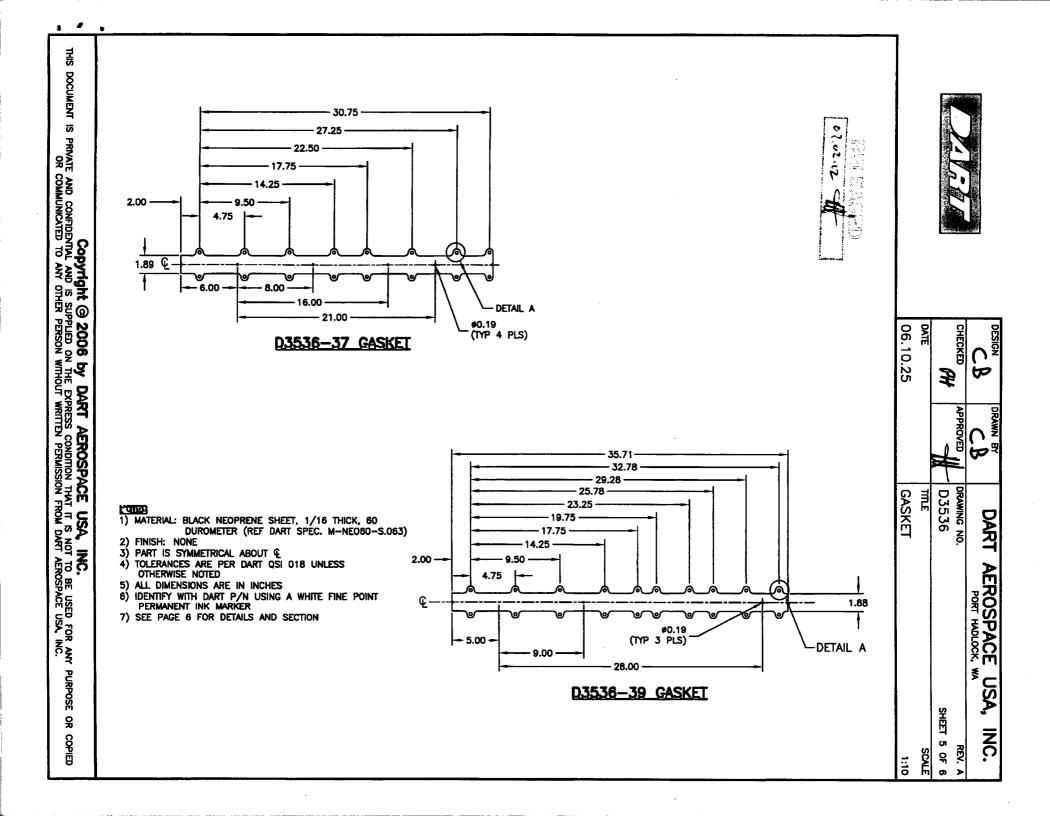
3) PART IS SYMMETRICAL ABOUT ©
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES
6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
7) SEE DAGE 6 FOR DETAILS AND SECTION.

7) SEE PAGE 6 FOR DETAILS AND SECTION



CB	CB	DAKI AEKOSPACE USA, INC.	, INC.
СНЕСКЕВ	IF DEMONDER	DRAWING NO.	REV. A
7	Z	D3536 SH	SHEET 4 OF 6
DATE		TUIT	SCALE
06.10.25		GASKET	1:10

DQA:			Date:															
						WORK ORDER NON-CONFORMANCE / UPDATE  Work Order update only												
QA Closed:			Date:							<u> </u>	Wc	ork Order up	date only					
Work Orde	r.					DISPOSITION				/PROCESS								
Work Orde	uei.					Rework	ı		Skid-tube		Water Jet			Engineering				
Part N	art No.					Scrap			Machining	┪	Prod. Eng. Coor.			Quality				
						Use-as-is			noforming		Rec/Store/Packaging			Other				
NCR N	lo.					Suspected Unapproved			Large Fab	Composite		Supplier						
Root					Descr	iption of work order update	ı	nitial	Actio	on		Sign &						
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descrip	otion		Date	Verification		QC Inspector			
Design																		
Doc/Data														ı				
Equip/Tooling			1															
Handling/Pre														1				
Material							İ											
Operator	_		1											-				
Offset/Setup																		
Process																		
Supplier																		
Training							ļ											
Transport																		
Unapproved																		
		-					FA	ULT CA	TEGORY									
Landir	ng G	1				General		1 ,	_	Г		1	. г					
		Bending	_		-	Bend	_	1	Program	-		Outside Dim	<u> -</u>	_	Pressure/Forced			
		Centre No	ot Concer	ntric	<u> </u>	BOM/Route	H	Grain		}	_	Over/Under		_	Set-up			
		Cracks			-	Broken/Damage/Defect		Hardwa				Part Incorred	<del>-</del>	_	Temperature/Cure			
		Crimp/Kir	nk/Ripple	/Wave	<u> </u>	Burrs	$\vdash$	4	tion Incomplete/Unc	· .	_	Part Lost/Mi	ssing	-	Weld			
	_	Cuffs			<u> </u>	Contamination	<u> </u>	4	tions Incomplete/Ur	nclear		Part Moved	L		Wrong Stock Pulled			
		Crushing			-	Countersink	-	4	gned/off center	-		Positioned V			Other			
		Heat Trea			$\vdash$	Cut Too Short	$\vdash$	Mislab		Į		Power Loss/	Surge		Other			
		Inspectio	-	Tube	-	Drawing	<u> </u>	Misrea										
	_	Marks/Ch			_	Drill Holes	$\vdash$	Off-set					·					
		Turning S			_	Finish	<u> </u>	4	Calibration									
	l	Wave/Tw	ist in Tuk	oe		Fit/Function		Out of	Sequence									



DQA:			Date:			AND CONTRACT AND STANKE AND STANK										
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE			<b></b>	AEROSPACE			
QA Closed:			Date:			Work Order update only										
Work Orde	er:					DISPOSITION			AGAINST	/PROCESS						
Work or ac	•					Rework			Skid-tube Crosstube	<u> </u>	7	Water Jet	Engineering			
Part N	lo.					Scrap			Machining Small Fab		Pro	d. Eng. Coor.	Quality			
					Use-as-is			moforming Finishing	Г	-	re/Packaging	Other				
NCR N	NCR No.					Suspected Unapproved Large Fab Compo					]	Supplier				
Root					Desci	ription of work order update	l	nitial	Action	-	Sign &					
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector			
Design																
Doc/Data			1													
Equip/Tooling																
Handling/Pre	_															
Material	_															
Operator																
Offset/Setup																
Process																
Supplier									1							
Training							1									
Transport																
Unapproved			<u> </u>		<u> </u>		<u> </u>				1					
							FAI	ULT CA	TEGORY							
Landi	ng (	Ī			_	General	_	1	Dun	_			7 (5)			
		Bending				Bend BOM (Boute	_	1	Program	-	Outside Dim	<del> </del>	Pressure/Forced			
		Centre No	ot Concer	itric		BOM/Route	<u> </u>	Grain		$\vdash$	Over/Under	<del> </del>	Set-up			
		Cracks				Broken/Damage/Defect	⊩	Hardwa		-	Part Incorred	<u> </u>	Temperature/Cure			
		Crimp/Kink/Ripple/Wave				Burrs	<u> </u>	1 .	tion Incomplete/Unqualified	-	Part Lost/Mi	SSING	Weld			
	_	Crushing			$\vdash$	Countersink	$\vdash$	4	tions Incomplete/Unclear	$\vdash$	Part Moved	L Vrong	Wrong Stock Pulled			
		Crushing Heat Trea				Countersink Cut Too Short	$\vdash$	Mislab	gned/off center	$\vdash$	Positioned V Power Loss/		Other			
		Inspection		Tubo	-	Drawing	<u> </u>	Misrea			Jrower Loss/	ouige [	Joulei			
		Marks/Ch	•	rube	_	Drill Holes	$\vdash$	Off-set								
	$\vdash$	Turning S			$\vdash$	Finish	-	4	Calibration							
,	<del> </del>	Wave/Tw			$\vdash$	Fit/Function	$\vdash$	-1	Sequence							
	l	į vvave/ i W	ISCHI TUL	) <del>C</del>	I	ji it/i ulicuoli	1	Journ	sequence							

- 27.98 25.08 18.50 15.00 2.00 1.88 4.00 ø0.19 (TYP 2 PLS) DETAIL A D3536-41 GASKET





DATE 06.10.25 CHECKED B

GASKET Ħ

DRAWING NO. DART

D

AEROSPACE PORT HADLOCK, 1 ≸

USA,

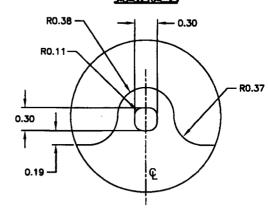
**₹** 

SCALE 1:10

됐

6 OF 6 REV.

**DETAIL** 



- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60
  DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE 3) PART IS SYMMI
- PART IS SYMMETRICAL ABOUT &
  TOLERANCES ARE PER DART QSI 018 UNLESS
  OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES
  IDENTIFY WITH DART P/N USING A WHITE FINE POINT
  PERMANENT INK MARKER

DQA:			Date:										TQ AC				
						WORK ORDER NON-CONFORMANCE / UPDATE											
QA Closed:			Date:				Work Order update only										
Work Orde	er:					DISPOSITION			AGA	PROCESS							
Work Orac	•	<u> </u>			_	Rework			Skid-tube Cross	tube		Water Jet	Engineering				
Part N	Part No.					Scrap			Machining Small	_	Pro	d. Eng. Coor.	Quality				
					Use-as-is			· —	hing	4	e/Packaging	Other					
NCR N	lo.					Suspected Unapproved			Large Fab Compo	osite	j	Supplier					
Root	_				Desci	ription of work order update		nitial	Action		Sign &						
Cause		Date	Step	Qty	Desci	or non-conformance		ief Eng			Date	Verification	QC Inspector				
Design			0.00	٦٠,			-										
Doc/Data																	
Equip/Tooling			:														
Handling/Pre																	
Material				į													
Operator							ļ										
Offset/Setup																	
Process													Í				
Supplier																	
Training																	
Transport																	
Unapproved							<u>L</u>										
							FA	ULT CA	TEGORY								
Landi	_	•			_	General		,		_	7	_	_				
	L	Bending			<u> </u>	Bend	Folio/Program			<u> </u>	Outside Dim	<u> </u>	Pressure/Forced				
		Centre No	ot Concer	ntric	ļ	BOM/Route		Grain		<u> </u>	Over/Under	<u> </u>	Set-up				
	Cracks				<u> </u>	Broken/Damage/Defect	<u> </u>	Hardwa	<del></del>		Part Incorred	<del>-</del>	Temperature/Cure				
		Crimp/Kir	nk/Ripple	/Wave	-	Burrs	<u> </u>	1 .	ion Incomplete/Unqualified	¹ <u> </u>	Part Lost/Mi	ssing	Weld				
	$\vdash$	Cuffs			-	Contamination	_	-	tions Incomplete/Unclear		Part Moved	<u>.</u> L	Wrong Stock Pulled				
	<u> </u>	Crushing			<u> </u>	Countersink	_	1	gned/off center		Positioned V		٦٠				
	_	Heat Trea			-	Cut Too Short	_	Mislab			Power Loss/	surge	Other				
	_	Inspectio		Tube	<u> </u>	Drawing	_	Misrea									
	<u> </u>	Marks/Ch			$\vdash$	Drill Holes	<u> </u>	Off-set				·					
	_	Turning S			$\vdash$	Finish	$\vdash$	1	Calibration		<del>.</del>						
		Wave/Tw	ist in Tub	oe		Fit/Function	1	Out of	Sequence								